

Date: Wednesday, 3/26/2008 9:49:52 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH  
 Job Number : 38155  
 Estimate Number : 10262  
 P.O. Number :  
 This Issue : 3/26/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D350636011  
 First Issue : 1 / 1 Type : LANDING GEAR Drawing Number : D2750 REV E  
 Previous Run : 38154 Drawing Revision : E  
 Material :  
 Due Date : 4/10/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JD 08.3.27  
 Comment : Est Rev: I 02-09-25 Rearranged procedure steps KJ  
 Est Rev: J 06-03-23 As per Rev D JLM  
 Est Rev: K 06-07-13 As per dsi9343 EC  
 Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM  
 Verified By: EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 003

08.4.15 JLD  
08.4.15

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B 37858

① W 3-4-14

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

B 33996

BE

08/04/15

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

3-4-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #: Machine Or Operation: Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

K 8-4-15

4-Drill pilot holes for Detail B using DT8330

5-Open up holes for Detail B to 0.375" and blade fitting location holes to 0.500" as per dwg D2750 .Open up detail E to 0.500".Open up ground handling holes to 0.500".

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297" \*\*\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\* Open holes to detail A to 0.297"

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod M106 330 BC 08/04/15

10-Grind welds flush as per Dwg D2750

K 8-4-17

12- Scribe batch# inside per dwg D2750

K 8-4-14

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/04/17 (K)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/17 (K)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RT 08-04-17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/17 (K)

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

B36871

①

K 8-4-17

## WORK ORDER CHANGES

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Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D34901	CROSS BOLT SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B-33824

BE 08/04/22

11.0	D34903	CROSS BOLT SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B-33825

BE 08/04/22

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B-36030

BE 08/04/22

13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail D to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

4-Deburr and blow out all chips from inside of tube

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: M 07397  
exp. date: 8-10-1

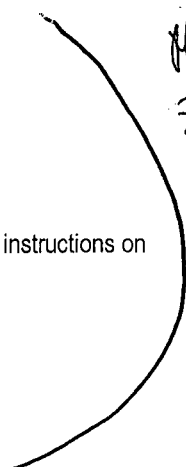
7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 4)

A/R Aluminum Rod batch: M 107263 BE 08/04/22

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

H  
8-4-17



SL-423

W/O:		WORK ORDER CHANGES						
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Seq. #:

Machine Or Operation:

Description :

10-Deburr holes

SL 8-4-23

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/04/23 (D)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/23 (D)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BL 08-04-24

(D)

B38155

D350636011

24/04/2008

S.108

13.09

#1

3319.9

#2

7-5-2

#3

#4

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

JPS 08-04-

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FD 08/04/24 (D)

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Insert

Batch: m100621

FD

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

FD 08/04/24 (D)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 637303

FD 08/04/25 (D)

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D353513

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37584

FL

23.0

D353525

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38162

FL

24.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37625

FL

25.0

D353613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B36635

FL

26.0

D353625

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B36636

FL

27.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38183

FL 08/4/25

28.0

D35371

WEARPAD



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

WEARPAD

Batch: B36426BR  
BR 08-04-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38155

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D36311

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B38139

FL

30.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B35586

FL

31.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B36902

FL

32.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B36237

FL

33.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: m106780

FL

34.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m105300

FL

35.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: m105906

FL 08/04/25 @

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: *m 107314*

*FL*

37.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: *m 106896*

*FL*

38.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: *m 107376*

*FL*

39.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: *m 106513*

*FL*

40.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: *m 107736*

*FL*

41.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: *m 106431*

*FL*

42.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: *m 106516*

*FL 08/04/25 ①*

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38155

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: m107581

FL

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: m105005

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m107804

EXP DATE: 08/10

FL 08/04/25 (1)

4-Coat all exposed fasteners with "LPS Procyon" batch: m104251

BR 08-04-29 (1)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

COO (a/05) (4)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 36343

AS 08/04/29 (X)

48.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m107596

AS 08/04/29 (X)

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description:

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch:

M107520

AS 08/04/29 (X1)

50.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch:

M107581

AS 08/04/29 (X1)

51.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch:

M107650

AS 08/04/29 (X1)

52.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch:

B33085 B36034

AS 08/04/29 (X1)

53.0

D35321

spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)

batch:

B33085

AS 08/04/29 (X1)

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/04/29 (X1)

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

Rev F 8/4/30 SP

(1/1)

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/01 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-01

38155

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 1 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

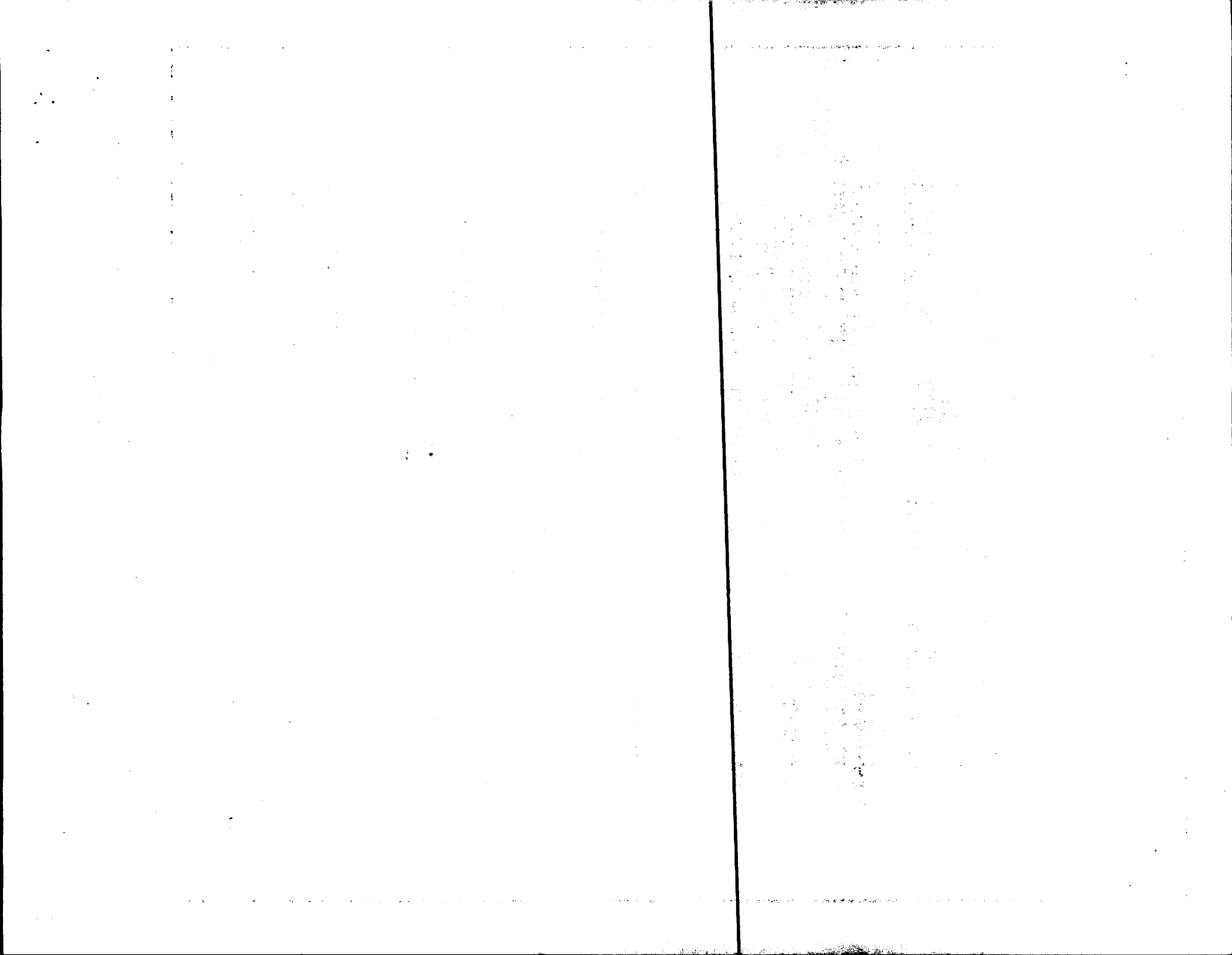
RELEASED  
07.08.02 *[Signature]*

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

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DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS

GENERAL NOTES:

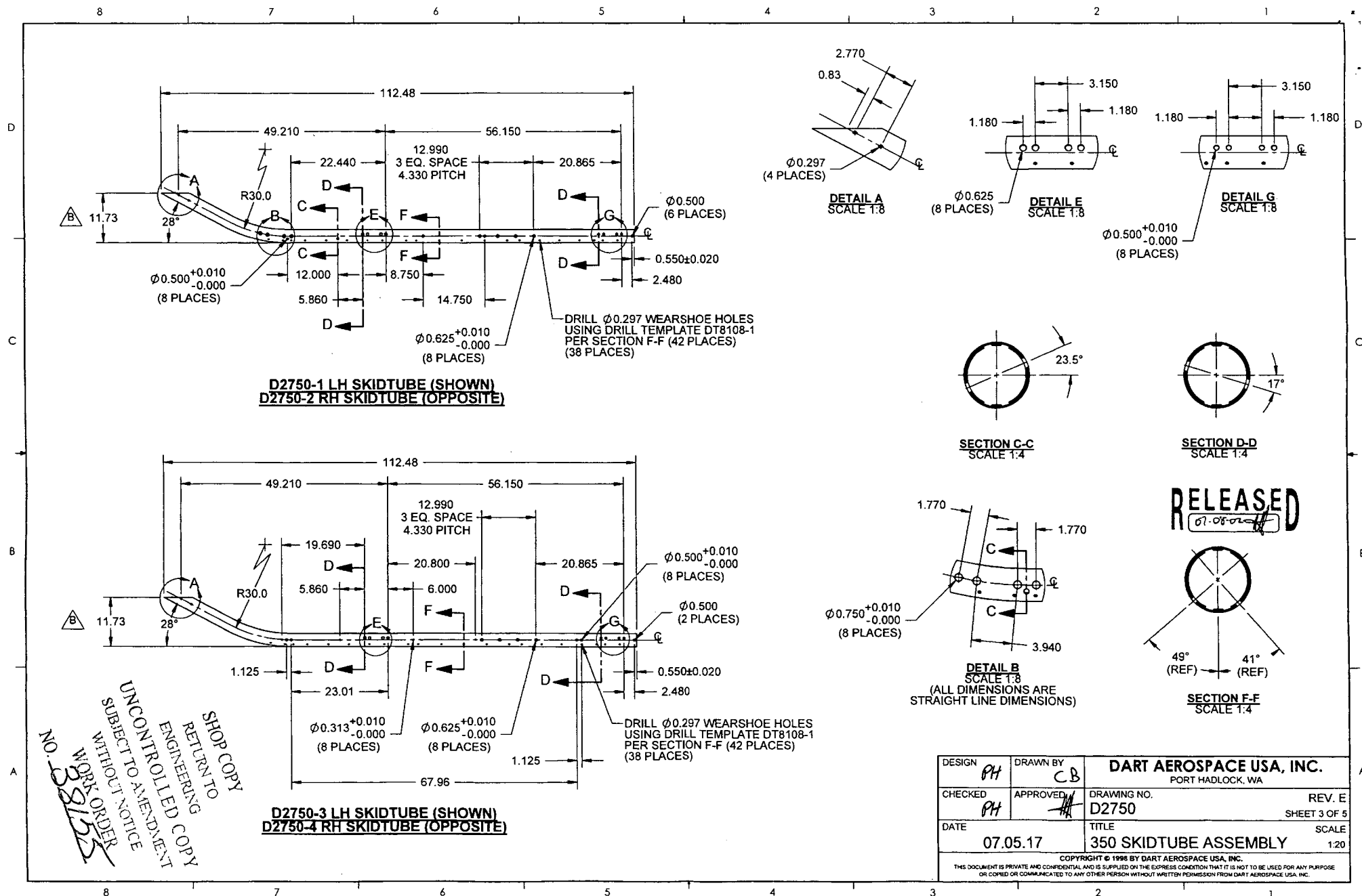
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1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS POWDER COATING WITH MEK DEGREASER.

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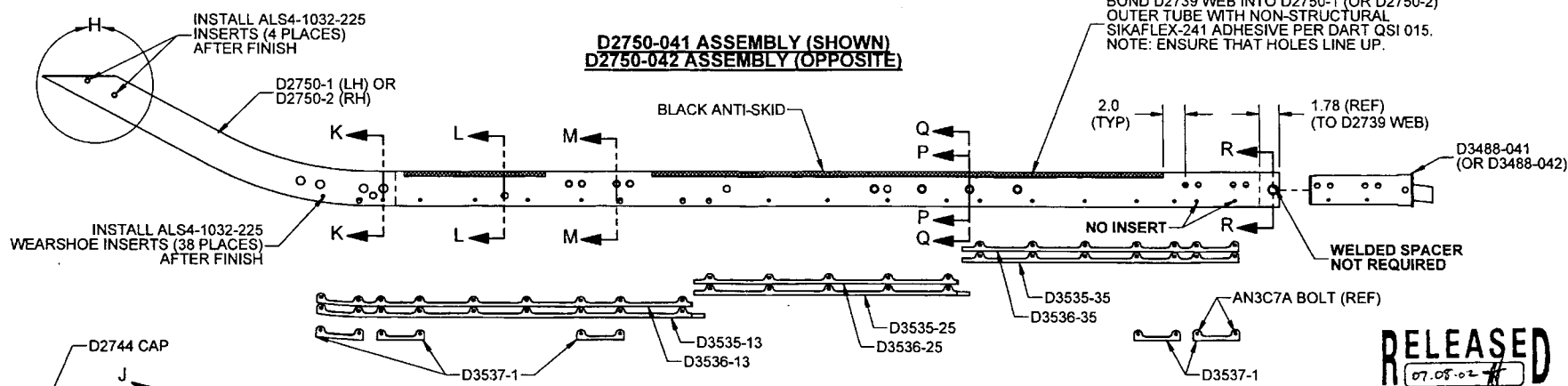
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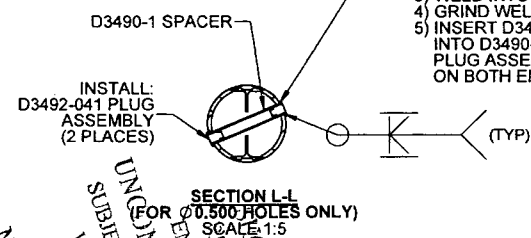
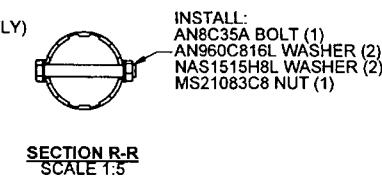
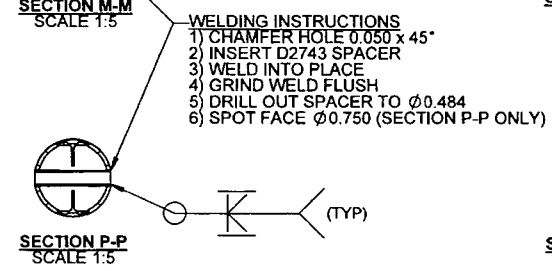
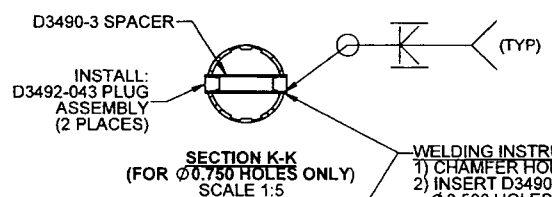
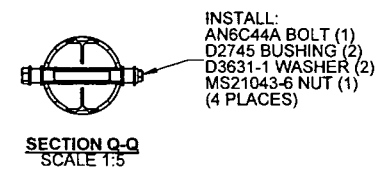
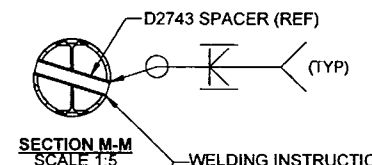
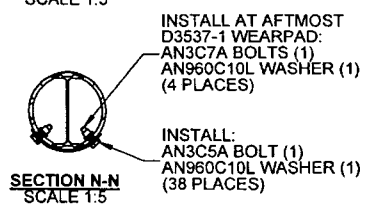
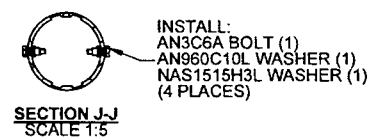
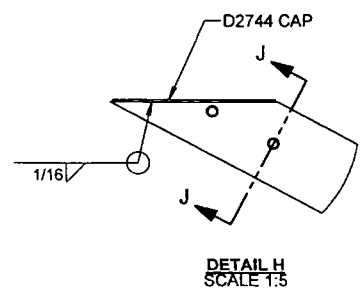
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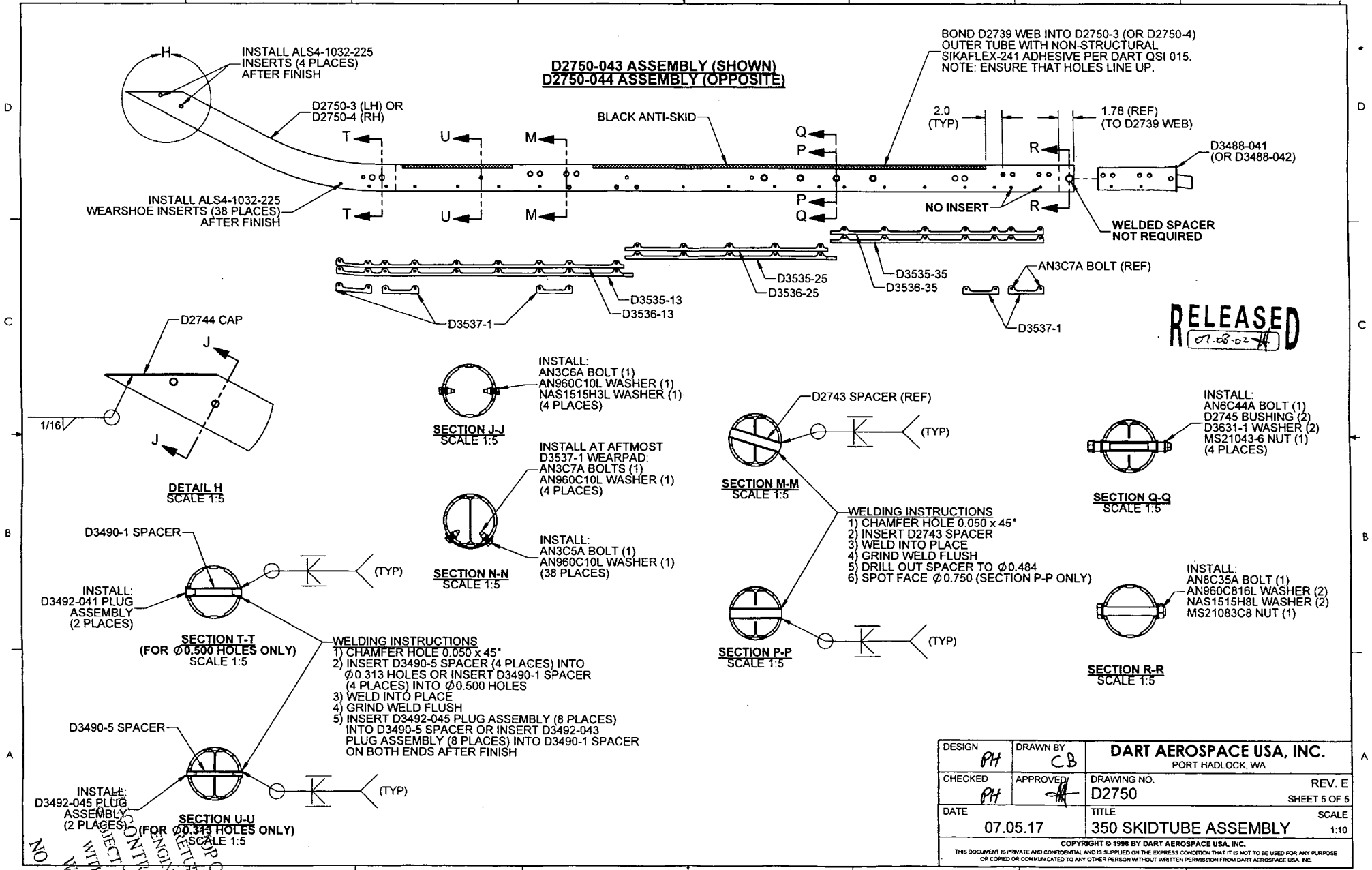


- WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 x 45°  
2) INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES  
3) WELD INTO PLACE  
4) GRIND WELD FLUSH  
5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS AFTER FINISH

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TITLE			350 SKIDTUBE ASSEMBLY		
SCALE			1:10		
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AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 37801  
Part number: D305 636 041 D350 636 041  
Description: 30 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[ ] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pct. Prod. Date of Test Coupon 08-04-23

Welder Barclay Elliot Date of Test Coupon 08-04-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld